

* Rush at MAY 7

Work Order ID 132194

132194

Friday, May 01, 2015 8:51:23 AM

Item ID: D5204-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket
Start Date: 5/01/15 Start Qty: 2.00 ~~*2*~~ 5 ~~*2*~~ 5 Cust Item ID:
Required Date: 5/06/15 Req'd Qty: 2.00 15/05/01 Customer:
Reference:

Approvals: Process Plan: M Date: 5-5-01 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	BAND SAW	0.00							DAS 08 9-8c
100						5	0		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks at 2.50"								
110	HAAS CNC VERTICAL MACHINING #1	0.00							DAS 08 9-8c
110						5	0		
HAAS 5AXIS	Memo	0.00							
HAAS CNC vertical machine #5	Machine per folio FB362								
	Folio rev: AA								
	Dwg. rev: A								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

Work Order ID 132194

Friday, May 01, 2015 8:51:23 AM

132194

Page 2

Item ID: D5204-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 5/01/15

Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/06/15

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

b. 15/05/02

5

0

DAS
08
9-89

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

5

0

DAS
37
15.05.04
9-89

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

5

0

15-5-5
JH

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Friday, May 01, 2015 8:51:23 AM

Page 3

5

DAS	DAS
28	38
9-89	9-89

9-59
MAY 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
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Work Order ID 132194

Friday, May 01, 2015 8:51:23 AM

132194

Page 4

Item ID: D5204-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 5/01/15 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/06/15 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST/ISO</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21 - Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

SX DAS 27 5-29
MAY 06 2015

MCS MAY 06 2015
MF
15-5-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Picklist Print

Friday, May 01, 2015 8:51:32 AM

Page 1

Work Order ID: 132194

132194

Parent Item: D5204-1

D5204-1

Parent Item Name: Bracket

Start Date: 5/01/15

Required Date: 5/06/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A RQ 15.01.15 verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	10.1680	0.208	1			

M6061T6B2 500X03 500

B. 15/05/02

6061-T6 Bar 2.50 x 3.50

Location

Loc Qty

Loc Code

MAT004

10.168

→ m129530

10.168

1.063 ft

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐																								
		OTHER : _____																							

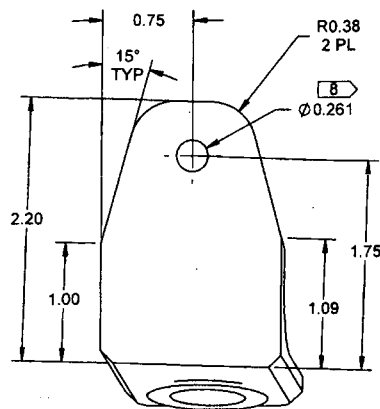
DART AEROSPACE LTD	Work Order:	132194
Description: Bracket	Part Number:	D5204-1
Inspection Dwg: D5204 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

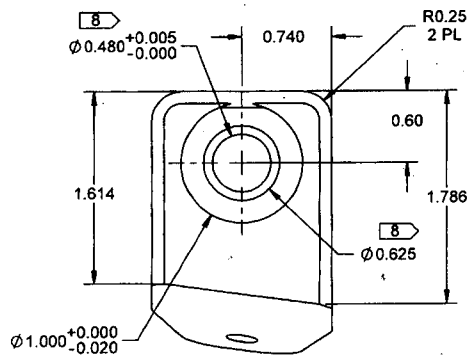
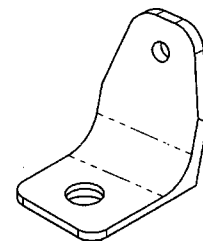
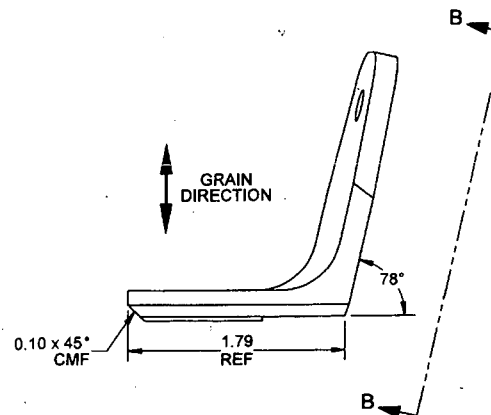
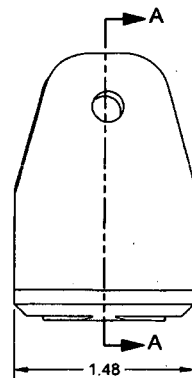
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/- .030	0.752	✓		Vern	GA-13
15°	+/- 1/2°	15°	✓		Angle M.	CNC-17
2.20	+/- .030	2.197	✓		Vern	GA-13
1.00	+/- .030	0.990	✓		"	"
1.09	+/- .030	1.090	✓		"	"
1.75	+/- .030	1.750	✓		"	"
φ0.261	+0.006/-0.001	φ0.262	✓		"	"
R0.38	+/- .030	R0.375	✓		R-6	ref.
1.48	+/- .030	1.481	✓		Vern	GA-13
0.10 x 45°	+/- .030 / +/- 1/2°	0.095 x 45°	✓		"	"
78°	+/- 1/2°	78°	✓		Angle M.	CNC-17
R0.25	+/- .030	R0.250	✓		R-6	ref.
0.740	+/- .010	0.7405	✓		Vern	GA-13
φ0.480	+0.005/-0.000	φ0.4825	✓		"	"
1.614	+/- .010	1.612	✓		"	"
φ1.000	+0.000/-0.020	φ0.994	✓		"	"
φ0.625	+/- .010	φ0.626	✓		"	"
1.786	+/- .010	1.788	✓		"	"
0.60	+/- .030	0.599	✓		"	"
0.188	+/- .010	0.189	✓		Mic	GA-03
0.035	+/- .010	0.035	✓		D-6	GA-08
R0.02	+/- .030	R0.032	✓		R-6	ref.
R0.01	+/- .030	R0.005	✓		"	"

Measured by: J. A. DAS	Audited by: 37 DAS	Preliminary Approval:
Date: 15/05/02 08:39	Date: 15.05.04	Date:

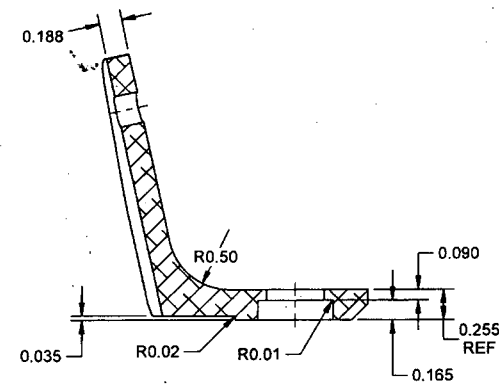
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



VIEW B-B



D5204-1 BRACKET



SECTION A-A

NOTES:

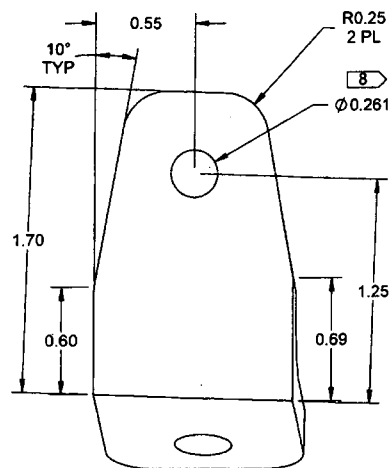
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T68
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

Handwritten: 132194

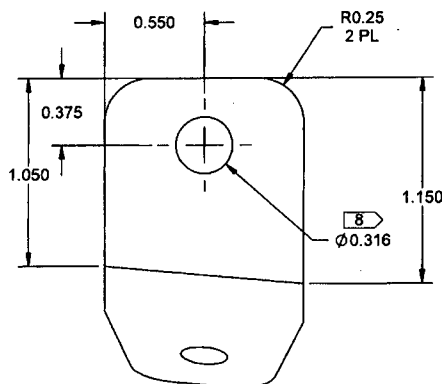
RELEASED
2015 JAN 29
ECN 15-508 4

APPROVED

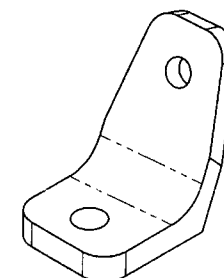
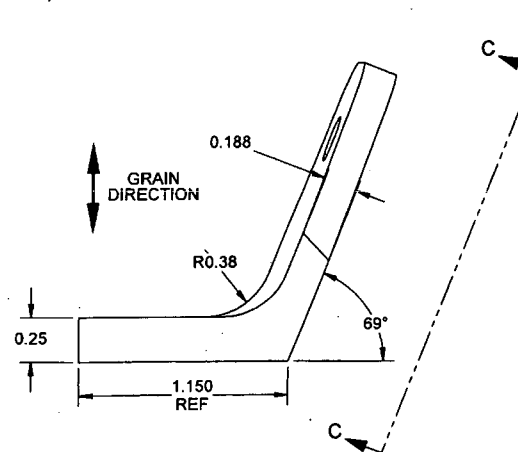
REV.	NEW ISSUE	RF	14.12.19
DESIGN	RF	DESCRIPTION	DATE
DRAWN	RF	DART AEROSPACE LTD	
CHECKED	AK	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	RQ	DRAWING NO. D5204	REV. A
APPROVED	HS	TITLE BRACKET	SHEET 1 OF 2
DE APPR.	DS	SCALE	NTS
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VIEW C-C



D5204-3 BRACKET



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

RELEASED

2015 JAN 29

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	RQ	D5204	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.12.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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